

Work Order ID 69496

Wednesday, May 11, 2011 1:42:50 PM



Page 1

Item ID: D3554-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Ball Stud

Start Date: 5/11/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/05/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3554	Rev A								

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14009 ☐ Purchase Part Number: BS104 ☐ Supplier: LS Technologies ☐ Certificate of conformity is required

CL 11/05/11 (12)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Rec'd 11/05/11 (12)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

8/10/11

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69496

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Item ID: D3554-7

Accept

Revision ID:

Item Name: Ball Stud

Start Date: 5/11/2011 Start Qty: 12.00

Required Date: 5/18/2011 Req'd Qty: 12.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>68</i> Memo	0.00 0.00							<i>11/15/19</i> <i>sf</i> <i>12</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/15/24</i> <i>MF</i> <i>11-05-20</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69496



Parent Item: D3554-7



Parent Item Name: Ball Stud



Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-11-13 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
BS104  BALL STUD		Purchased	No			110	Each	0.0000	1 	12		<i>P4/10/11</i> (12)	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

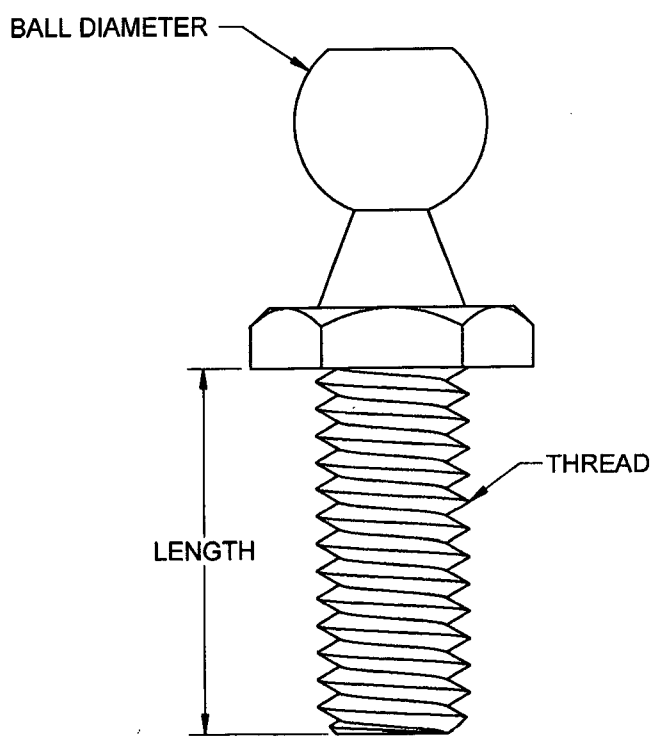


DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3554	REV. A SHEET 1 OF 1
DATE 06.08.28		TITLE BALL STUD	SCALE NTS
REV A	DATE 06.08.28	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
06.10.13



D3554-X BALL STUD

DART P/N	MATERIAL	BALL DIA	THREAD	LENGTH	POSSIBLE SUPPLIER
D3554-1	304 SS	10 mm	5/16-18 UNC	0.75"	McMASTER-CARR, P/N 9512K98
D3554-3	STEEL	10 mm	5/16-18 UNC	0.5"	McMASTER-CARR, P/N 9512K73
D3554-5	316 SS	10 mm	5/16-18 UNC	0.75"	McMASTER-CARR, P/N 9512K88
D3554-7	STEEL ZINC PLATED	10 mm	5/16-18 UNC	0.75"	LS TECHNOLOGIES, P/N BS104
D3554-9	STEEL ZINC PLATED	10 mm	5/16-18 UNC	1"	LS TECHNOLOGIES, P/N BS106

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14069

Purchase Order Date 5/11/2011

PO Print Date 5/16/2011

Page Number 1 of 2

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name

Vendor Phone 306 683 5000

Vendor Fax 306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

EX 11/15/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	BS104	BALL STUD	5/20/2011 Yes	12.00 Each	FedEx PI collect	\$1.1200	\$13.44
		Special Inst:	AS PER DWG D3554 REV. A B69496				
2	6/15-164/50-115N	Gas Spring	5/20/2011 Yes	20.00 Each	FedEx PI collect	\$63.9000	\$1,278.00
		Special Inst:	AS PER DWG D2807 REV. E B69671				
3	B6-220-530-140N	Door Prop	5/20/2011 Yes	10.00 Each	FedEx PI collect	\$36.8500	\$368.50
		Special Inst:	AS PER DWG D3552 REV. G B69668				
4	B8-154-387-156N	Gas Spring	5/20/2011 Yes	12.00 Each	FedEx PI collect	\$26.5000	\$318.00
		Special Inst:	AS PER DWG D3552 REV. G B69670				

5/16/2011

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
5/16/2011	7288

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
14069	5/16/2011	Fed-Ex		

Qty	Description
12	BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut
20	D2807 Stainless Gas Spring (6/15-164/50-115N)
10	B6-220-530-140N Gas Spring
12	B8-154-387-156N Gas Spring
12	B8-154-387-60N Gas Spring
Shipping Via FED EX Tracking # 797101196445	



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

12 Units : BS104 .39 DIA BALL STUD ZINC PLATED
5/16-18 THREAD .75 LENGTH W/Locknut

W/locknut

20Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

10 Units: B6-220-530-140N Carbon Steel Gas Spring

~~12~~ Units: B8-154-387-156N Carbon Steel Gas Spring

12 Units: B8-154-387-060N Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : May 2011

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 14069

Invoice # 7288

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr", written over a horizontal line.

Nolan Fehr
Manager